

Date: Monday, 3/17/2008 11:57:18 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : AFT CROSSTUBE
Job Number : 38041	
Estimate Number : 10377	
P.O. Number :	Part Number : D2890
This Issue : 3/17/2008 S.O. No. :	Drawing Number : D2890 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : PURCHASED PARTS	Drawing Revision : B
Previous Run : 38040	Material :
Written By :	Due Date : 4/4/2008 Qty: 1 Um: Each
Checked & Approved By : <u>Handwritten Signature</u>	
Comment : Est. D 05.03.21 Removed Bending procedures KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D6008180	Crosstube extrusion
-----	----------	---------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part #	Description	Batch
1	D6008-180	Crosstube extrusion	B34688 DP 8-3-31

2.0	BENDING	BENDING MACHINE
-----	---------	-----------------



Comment: BENDING MACHINE

1-Bend D2890 as per Dwg D2890 and Folio FT002

DP 8-3-31 (Pic)

3.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------



Comment: DIMENSIONAL CHECK

4.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
-----	----------------	-------------------------



Comment: LANDING GEAR RESOURCE 1

1-Deburr and Polish

NIA

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



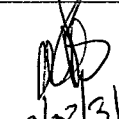
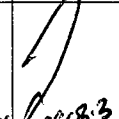

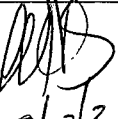
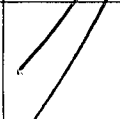
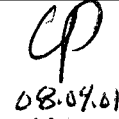
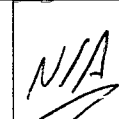

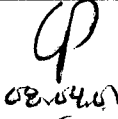
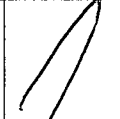
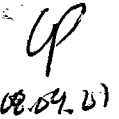
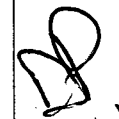


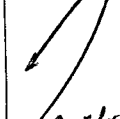
Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D 2890 PAR #: NIA Fault Category: Pred / x-tube NCR: Yes No DQA: D Date: 08/04/14
 QA: N/C Closed: D Date: 09/04/14

NCR: 38041		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08.03.31	2.0	Tube is over bent by 0.9875" on one side. R.c: New program being made for the new bend.	 08/03/31	- Quarantine tube & identify with P/N: B# for future un-bend testing per PAR. - Replace Q1 B34688	 08/03/31	 08/03/31	 08/03/31	 08/03/31
08.04.01	2	Tube is over bent by 0.2" on one side, 0.3" on other. This is the replacement tube	 08.04.01 Q51042	Tube acceptable. Cut at 29.9" to maximize width.	 N/A	 08/04/02	 08.04.01 Q51042	 08/04/02
08.04.01	2	Tube over bent by 0.9875	 08.04.01 Q51042	SCRAP TUBE.	 08/04/01	 08/04/02	 08/04/01	 08/04/02

NOTE: Date & initial all entries

Date: Monday, 3/17/2008 11:57:18 AM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT CROSSTUBE

Job Number: 38041

Part Number: D2890

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: W/D 37950

Signature
060402

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-04-03

h

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

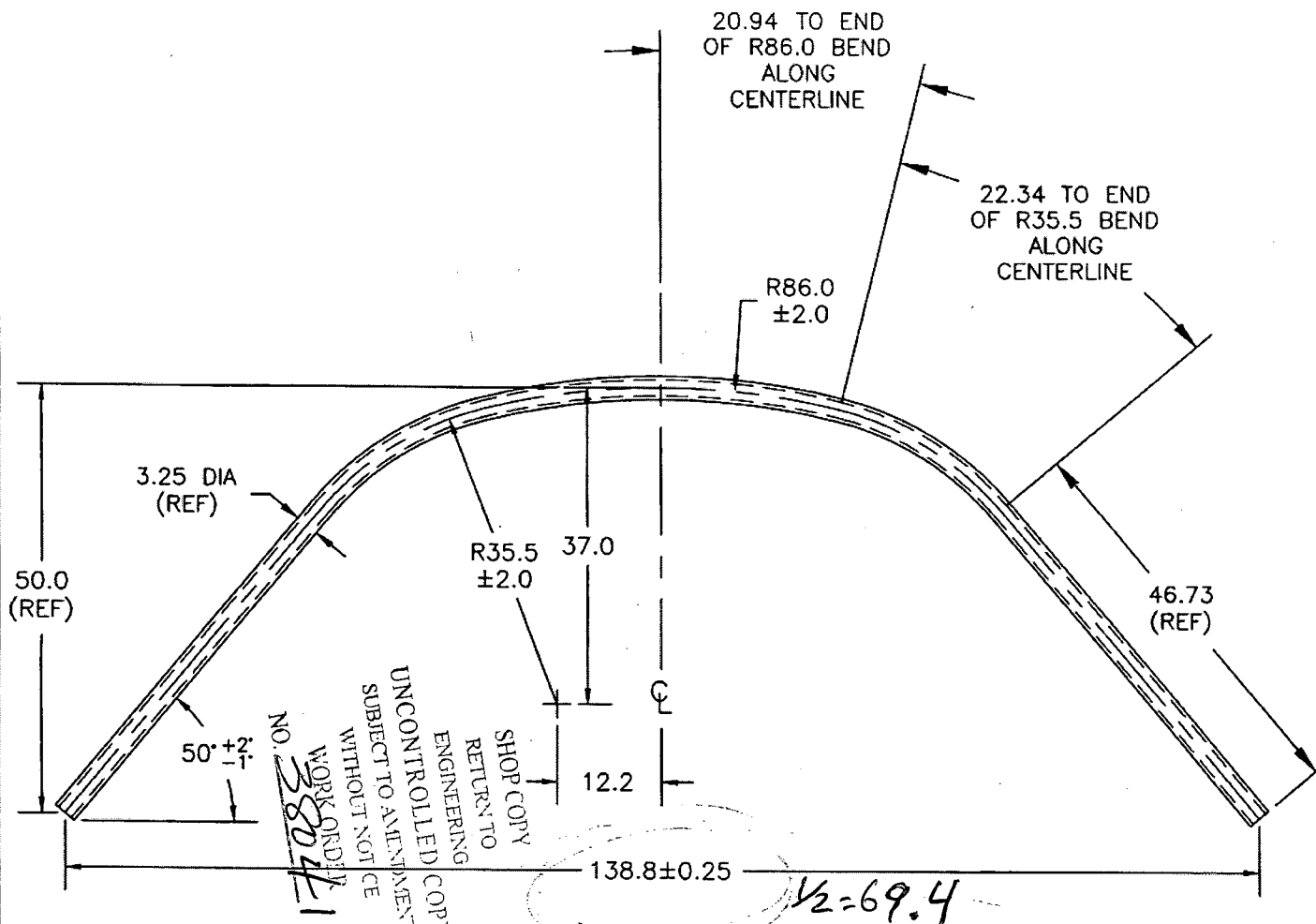
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART**RELEASED**
02.10.28

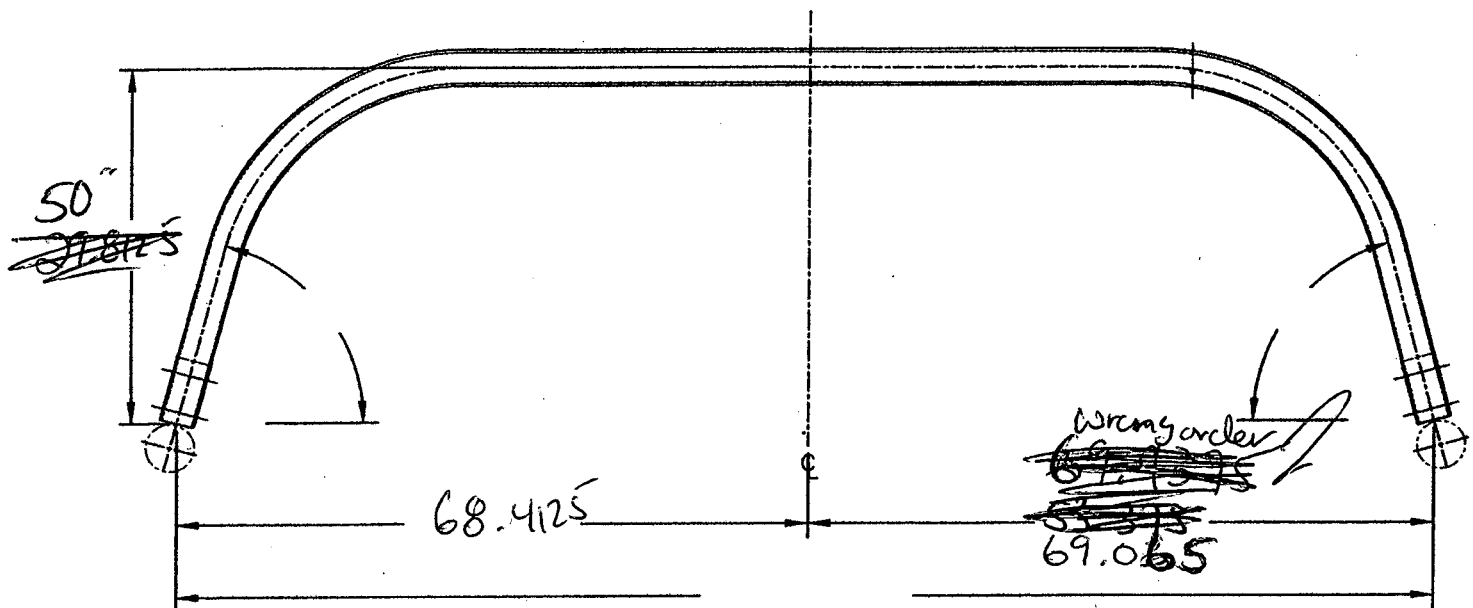
DESIGN		DRAWN BY		DART AEROSPACE LTD	
CHECKED		APPROVED		DRAWING NO.	
DATE		TITLE		REV. B	
02.10.18		AFT CROSSTUBE		SHEET 1 OF 1	
A		99.05.21		SCALE	
B		02.10.18		1:20	
		NEW ISSUE			
		ADD TANGENT LENGTHS; CHANGE NOTES			

**NOTES**

- 1) MATERIAL: MANUFACTURE FROM D6008-180 (Ø3.25 OD x 0.438 WALL)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BEND PROGRESSIVELY WITH MINIMUM OF 3 PASSES
- 6) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.

DART AEROSPACE LTD		Work Order: 3350 38041
Description: Crosstube Aft		Part Number: D2890
Inspection Dwg: D2890	Rev: B	Page 1 of 1

Required Dimension	Min	Max
Height	49.875	50.125
1/2 Span	69.275	69.525
Angle	49	52
Total Span	138.55	139.05



Comments
Tube is scrap.

QC15 Inspection	
Date	

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	